

Date: Friday, 01/08/2008 3:32:28 PM
 User: Julie Lecocq

Process Sheet

ASAP

| | | | | | | | |
|---|---|--|----------------|------------------|-------------------------|------|----|
| Customer | CU-DAR001 Dart Helicopters Services | | | Drawing Name | FRONT OUTBOARD LEG (RH) | | |
| Job Number | 40974 | | | Part Number | D37684 | | |
| Estimate Number | 13377 | | | Drawing Number | D3768 REVA | | |
| P.O. Number | | | | Project Number | N/A | | |
| This Issue | 01/08/2008 | S.O. No. | : | Drawing Revision | A | | |
| Prsht Rev. | NC | | | Material | : | | |
| First Issue | / / | Type | MACHINED PARTS | Due Date | 21/08/2008 | Qty: | 10 |
| Previous Run | 40712 | | | Um: | Each | | |
| Written By | | | | | | | |
| Checked & Approved By | JL 08.8.05 | | | | | | |
| Comment | Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC | | | | | | |
| Additional Product | | | | | | | |
| Job Number:  | | | | | | | |
| Seq. #: | Machine Or Operation: | Description : | | | | | |
| 1.0 | M6061T6T1000W065 | 6061T6 RD TUBE 1.00 x .065w  | | | | | |
| Comment: Qty.: 0.8969 f(s)/Unit Total : 8.9691 f(s) 108340 X 3.416 ^b 6061T6 TUBE (1.00" x 0.65" wall) 107950 X 1.708 ^a batch: M108819 2.983" 2.562" PQ 08/08/08 | | | | | | | |
| 2.0 | DOOSAN LATHE | DOOSAN LATHE  | | | | | |
| Comment: Doosan Lathe 1- Turn as per Folio FA758 Rev: <u>A</u> & Dwg D3768 Rev: <u>10</u> 2-Deburr per dwg D3768 PQ 08/08/08 | | | | | | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE  | | | | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE PQ 08/08/08 (10) | | | | | | | |
| 4.0 | QC8 | SECOND CHECK  | | | | | |
| Comment: SECOND CHECK JL 08/08/08 | | | | | | | |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1  | | | | | |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 JL 08-08-06 X18 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:28 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (RH)

Job Number: 40974

Part Number: D37684

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M18052



10X

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

71:00

MF 08/08/08

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-08

DP
100

8.0 PACKAGING 1

PACKAGING RESOURCE #1



8/8/08



SB

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 118

9.0 QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

AD 08/08/08

Job Completion



MF 08-08-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

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D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH

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08.06.16 JMH

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NO. 40974

A

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

8 7 6 5 4 3 2 1

| A | NEW ISSUE | HS | 08.06.04 |
|------------|-------------|--|--------------|
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3768 | SHEET 1 OF 4 |
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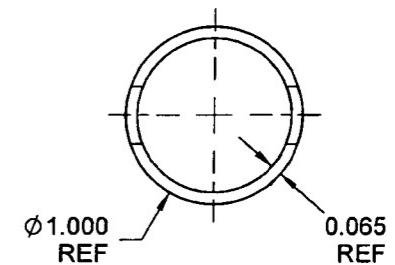
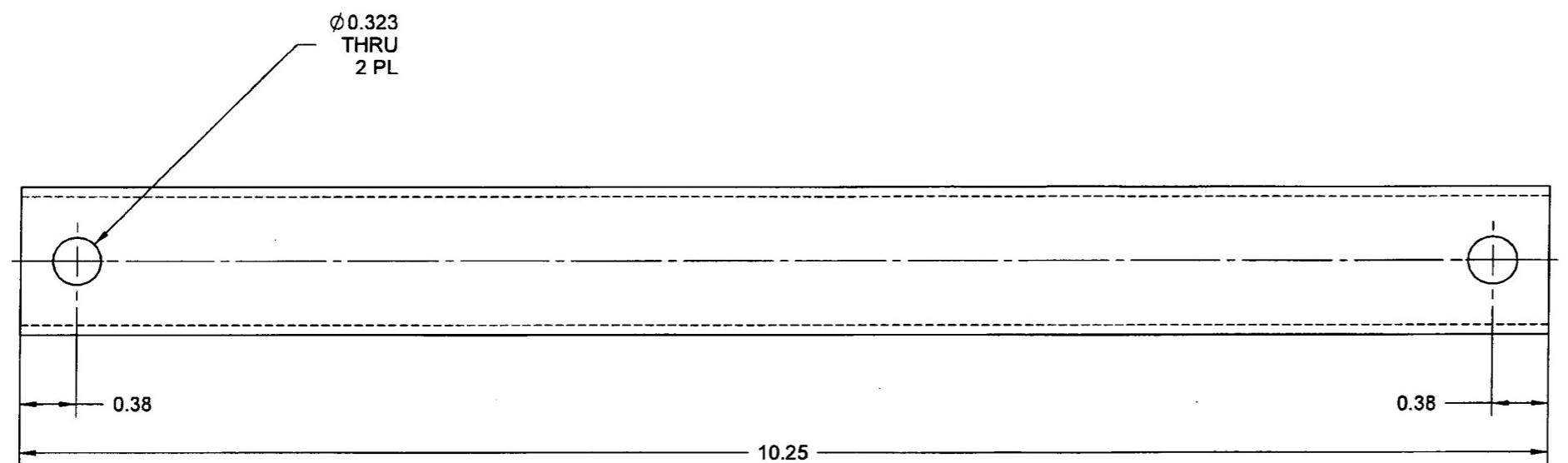
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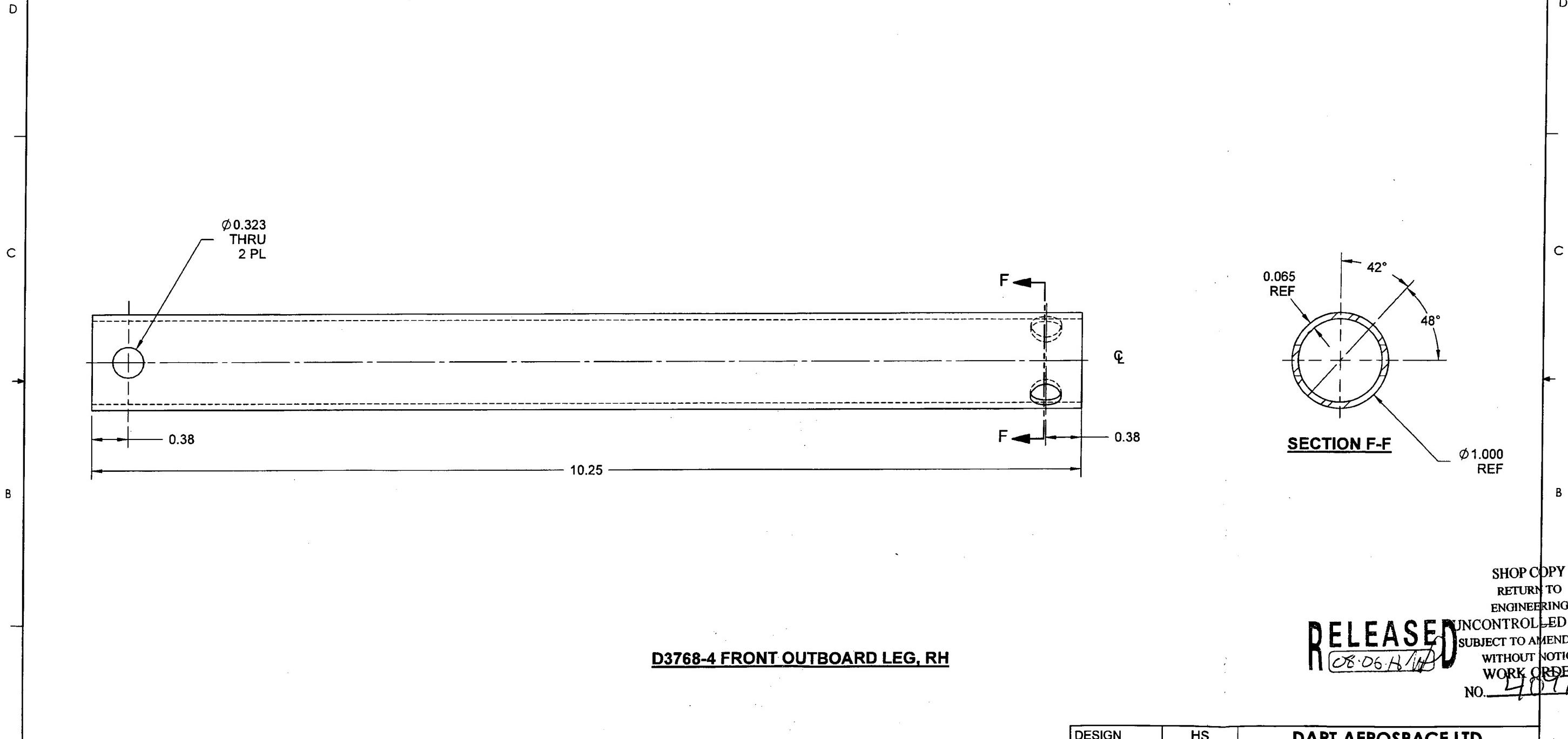


D3768-1 FRONT INBOARD LEG

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| CHECKED | PJ | DRAWING NO. |
| MFG. APPR. | M | D3768 |
| APPROVED | M | SHEET 2 OF 4 |
| DE APPR. | M | TITLE |
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| MFG. APPR. | AM | D3768 | REV. A |
| APPROVED | MM | SHEET 4 OF 4 | SCALE |
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|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: | Part Number: | |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|---|-------------|---|---------------------|--|
| Measured by: |  | Audited by: |  | Prototype Approval: | |
| Date: | 08/08/06 | Date: | 08/08/06 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|-----------------|
| A | | New Issue | KJ/JLM | |